

Work Order ID 64334

Page 1

Thursday, December 02, 2010 1:38:57 PM

Item ID: D4106-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Crew Door Doublber, RH

Start Date: 12/2/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: PPDate: 10-12-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4106

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

304.050

2-Deburr if necessary

B 10-12-17

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64334

Thursday, December 02, 2010 1:38:57 PM

Page 2

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Start Date: 12/2/2010 Start Qty: 4.00

Required Date: 12/15/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Memo

0.00



Small Fab

Memo

0.00

Small Fab

1- C'sink holes as per dwg

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



S 12/12/17

(24)

S 12/12/21 (4)

(24)

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 64334

Page 3

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Setup Start



Revision ID:

Stop



Item Name: Crew Door Douber, RH

Start Date: 12/2/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 128

0.00



Packaging

Memo

0.00

Packaging

Crew/21 (4)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/21 MF
10-12-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, December 02, 2010 1:39:01 PM

Page 1

Work Order ID: 64334

Parent Item: D4106-4

Parent Item Name: Crew Door Doulber, RH





Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 		Purchased	No			100	sf	122.6200	0.2006	0.844632			
304/316 .050 Sheet												12-10-12-17	

Location

Loc Qty

Loc Code

MAT		96
116135		96
MAT20		26.62
111743		4.75
113062		20.77
115389		1.1

116135

(4)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries

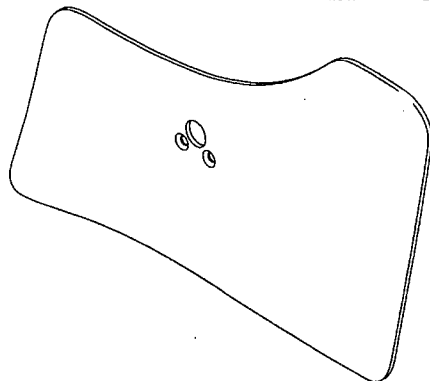
DART AEROSPACE LTD		Work Order:	64334
Description: Crew Door Doubler, LH		Part Number:	D4106-3
Inspection Dwg: D4106 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

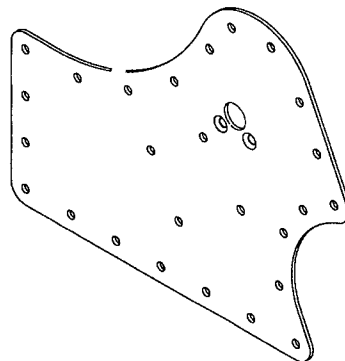
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.128	X		VIB 02	
Ø0.375	+0.006/-0.001	.375	X		V	
1.16	+/-0.030	1.156	X		V	
2.55	+/-0.030	2.048	X		V	
2.86	+/-0.030	2.861	X		V	
3.37	+/-0.030	3.373	X		V	
3.48	+/-0.030	3.483	X		V	
3.87	+/-0.030	3.871	X		V	
4.57	+/-0.030	4.570	X		V	
5.07	+/-0.030	5.070	X		V	
5.37	+/-0.030	5.376	X		V	
1.00	+/-0.030	1.002	X		V	
1.85	+/-0.030	1.846	X		V	
2.37	+/-0.030	2.37	X		V	
2.72	+/-0.030	2.719	X		V	
0.254	+/-0.010	.254	X		V	
3.20	+/-0.030	3.202	X		V	
0.508	+/-0.010	.507	X		V	
3.35	+/-0.030	3.351	X		V	
3.99	+/-0.030	3.988	X		V	
4.57	+/-0.030	4.576	X		V	
0.25	+/-0.030	.249	X		V	
0.25	+/-0.030	.250	X		V	
1.04	+/-0.030	1.043	X		V	
1.84	+/-0.030	1.840	X		V	
2.45	+/-0.030	2.449	X		V	
2.63	+/-0.030	2.631	X		V	
2.94	+/-0.030	2.942	X		V	
3.42	+/-0.030	3.427	X		V	
3.93	+/-0.030	3.934	X		V	
4.03	+/-0.030	4.033	X		V	
4.21	+/-0.030	4.218	X		V	
4.71	+/-0.030	4.712	X		V	
4.79	+/-0.030	4.791	X		V	
5.01	+/-0.030	5.01	X		V	
5.13	+/-0.030	5.13	X		V	
5.67	+/-0.030	5.671	X		V	

FIRST ARTICLE INSPECTION CHECKLIST

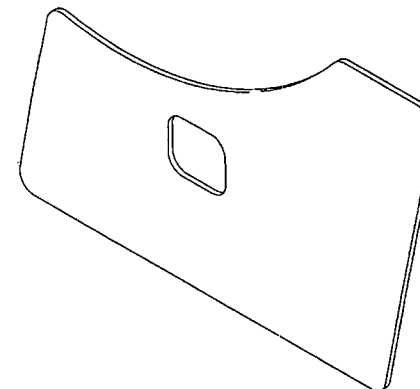
Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	



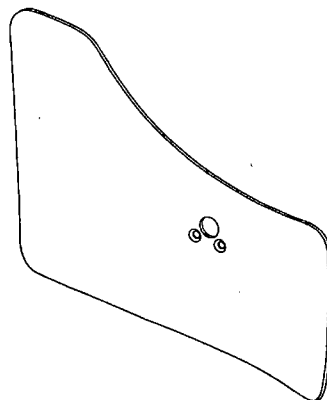
D4106-1 SILL DOUBLER, LH



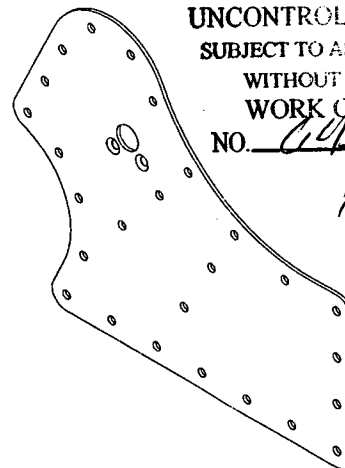
D4106-3 CREW DOOR DOUBLER, LH



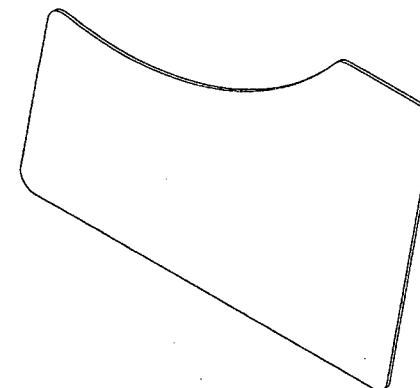
D4106-5 SPACER, SILL DOUBLER



D4106-2 SILL DOUBLER, RH



D4106-4 CREW DOOR DOUBLER, RH



D4106-7 TEMPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64334
210-123

RELEASED
2010-09-23
JM

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4106 TITLE DOUBLERS	JPH	10.07.15
DRAWN	JPH			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR.				
DATE	10.07.15			

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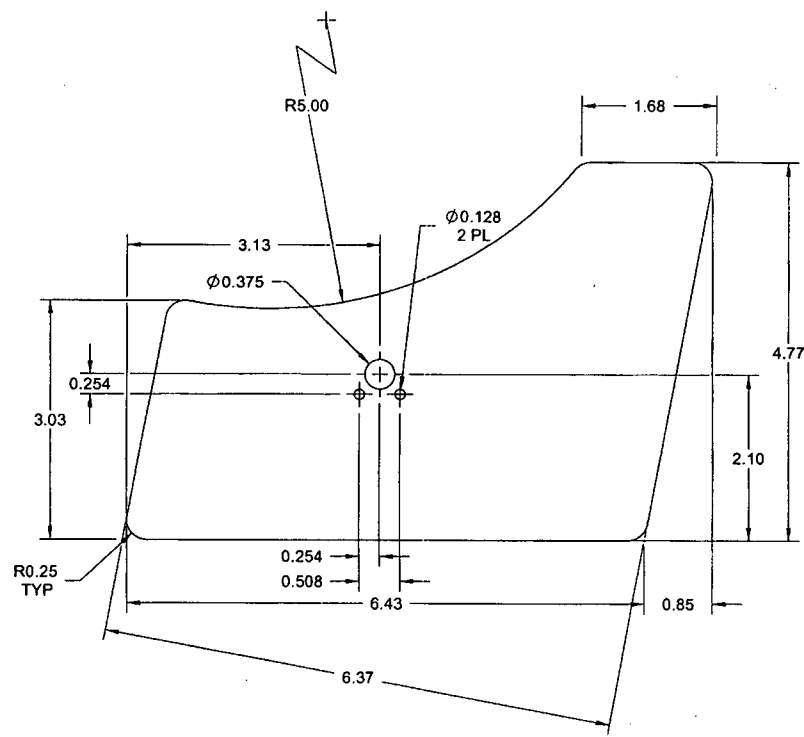
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

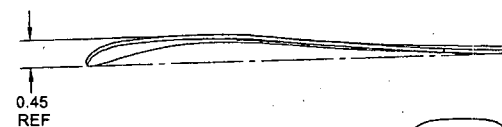
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

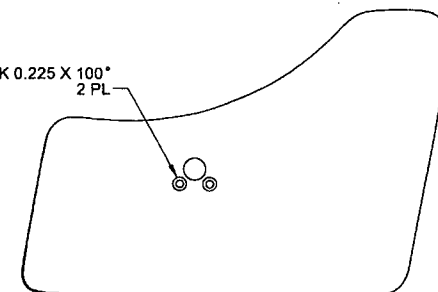
NOTE: Date & initial all entries



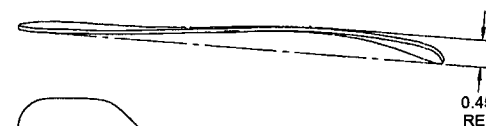
D4106-1F FLAT PATTERN, SILL DOUBLER



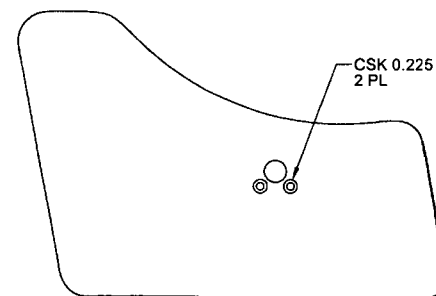
CSK 0.225 X 100°
2 PL



D4106-1 SILL DOUBLER, LH
(MAKE FROM D4106-1F)



CSK 0.225 X 100°
2 PL



D4106-2 SILL DOUBLER, RH
(MAKE FROM D4106-1F)

NOTES:

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
- 1 & -2: MAKE FROM D4106-1F.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -1 & -2: IDENT P/N D4106-X AND B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.34 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9646 FOR D4106-1
DT9647 FOR D4106-2

w/o 64334

RELEASE
2010-09-13

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4106	REV. A
MFG. APPR.	JPH	SHEET 2 OF 5	
APPROVED	JPH	TITLE DOUBLERS	SCALE NTS
DE APPR.	JPH	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.07.15		

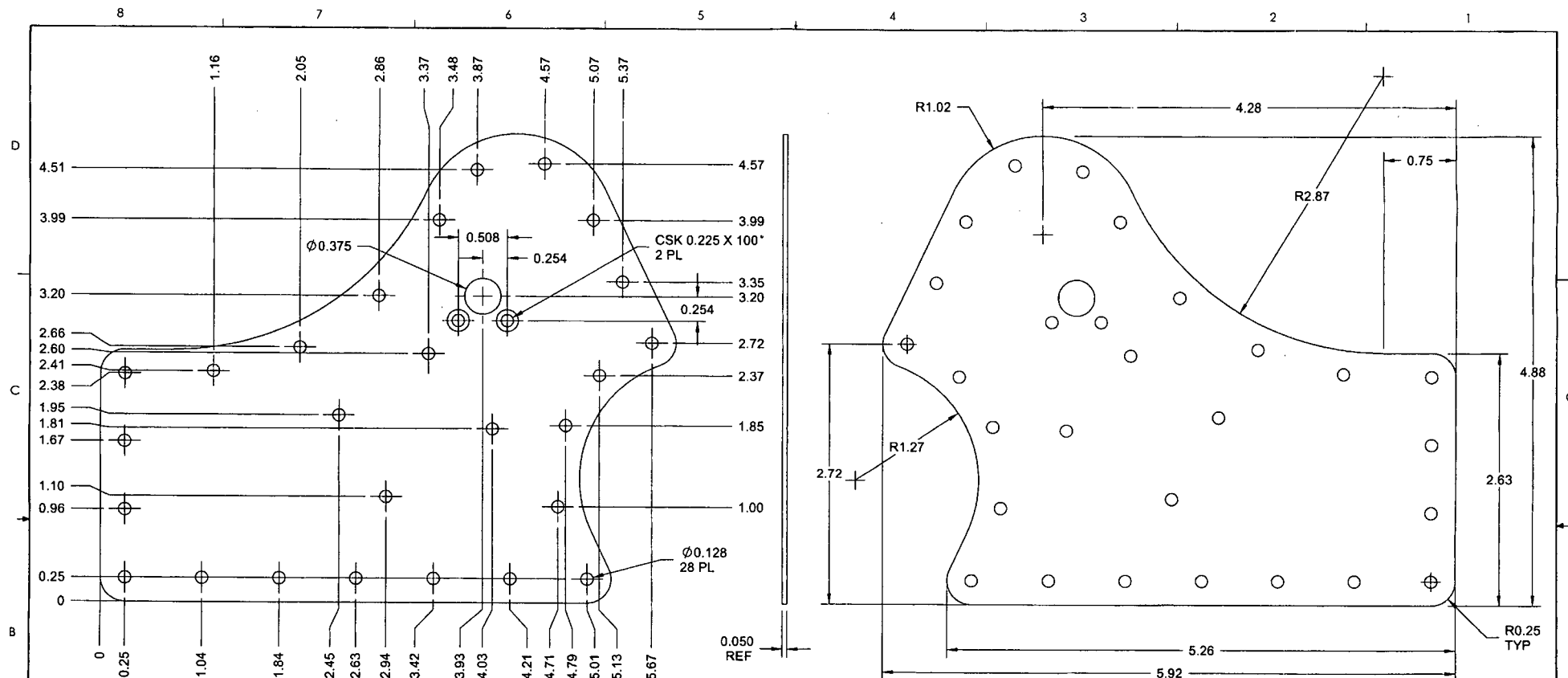
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







D4106-3 CREW DOOR DOUBLER, LH

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-3 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

w/o 64334

RELEASED
2010-09-23

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4106	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS	NTS
DATE	10.07.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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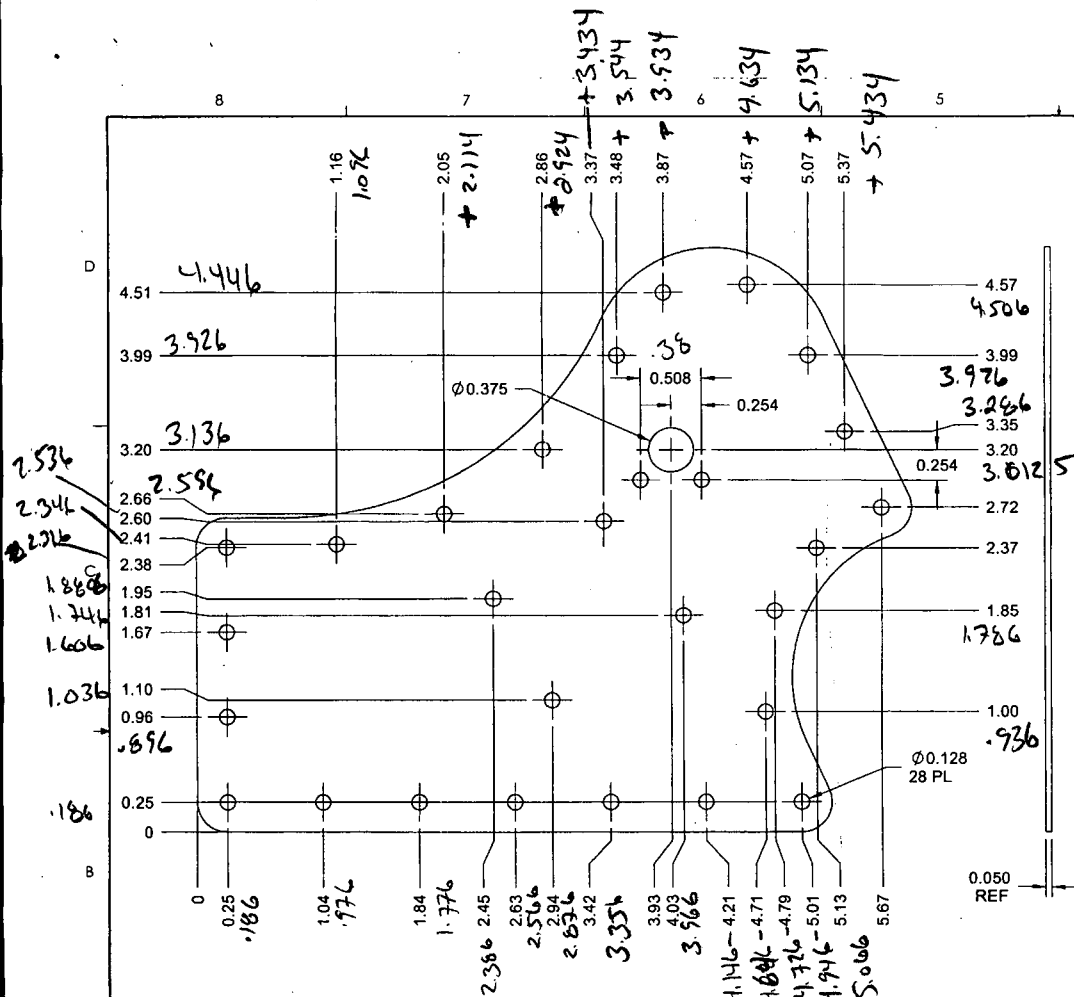
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

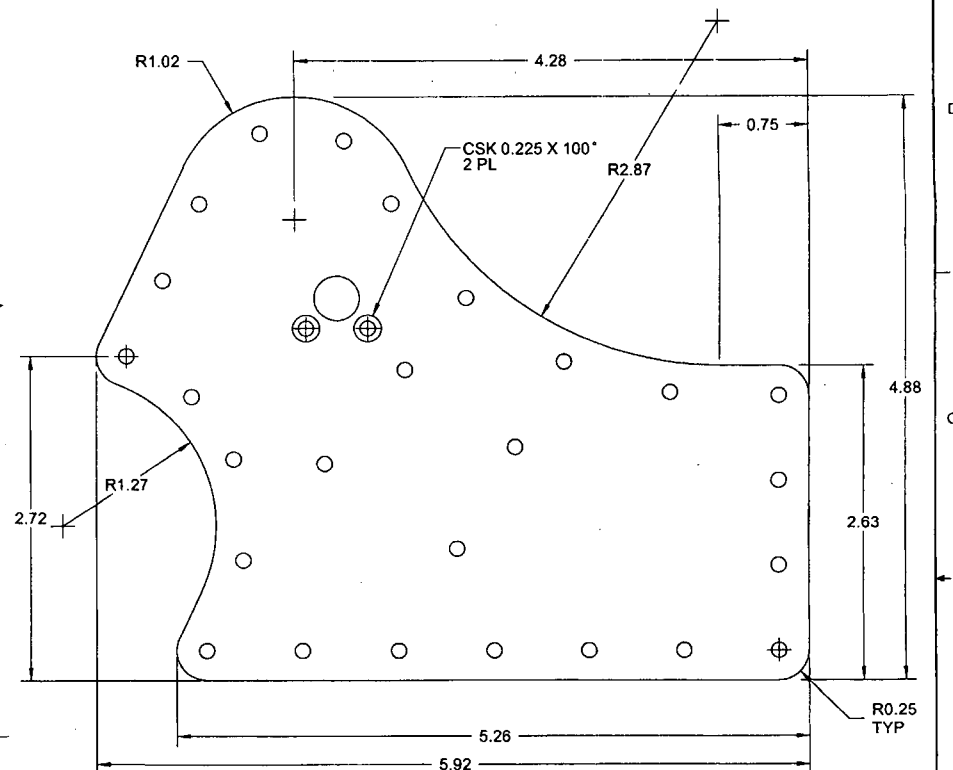
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NOTE: Date & initial all entries



D4106-4 CREW DOOR DOUBLER, RH



NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-4 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4106	REV. A SHEET 4 OF 5
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DE APPR.	JPH		
DATE	10.07.15		

RELEASED
2010-09-23

w/o 64334

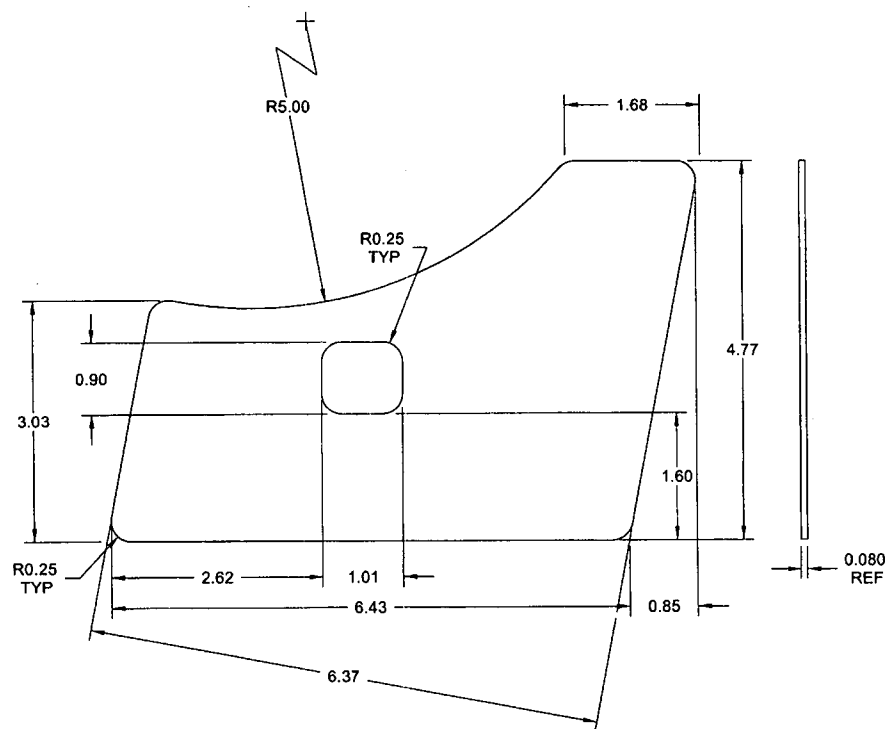
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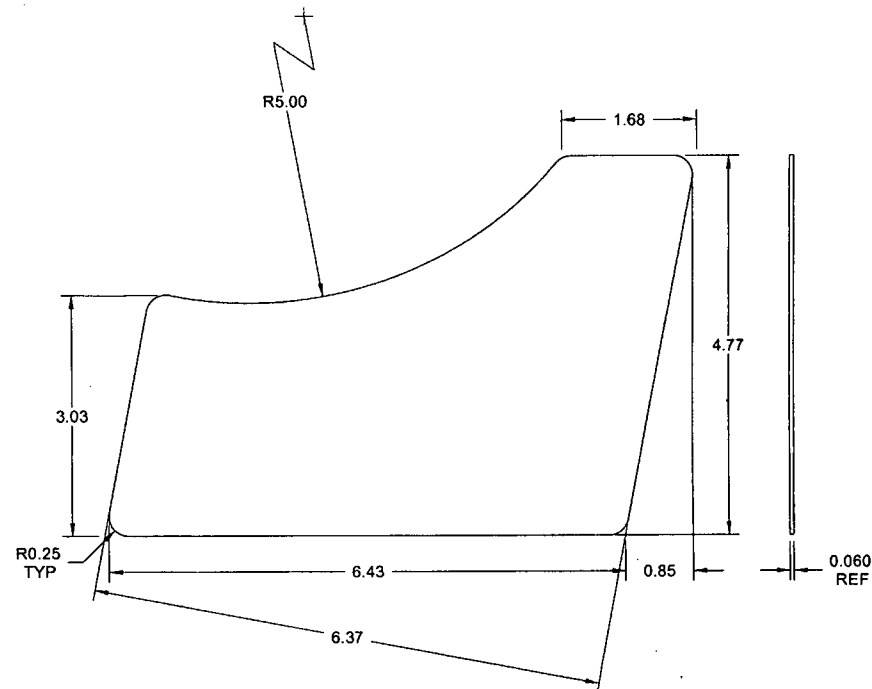
NOTE: Date & initial all entries



D4106-5 SPACER, SILL DOUBLER

NOTES:

- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015
- 7: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS.060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
- 7) WEIGHT -5: 0.08 lbs
-7: N/A



D4106-7 TEMPLATE

u b u4334

RELEASED
2010-09-23
MM

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4106	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE DOUBLERS	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	SCALE	NTS
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DATE	10.07.15		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries